

Work Order ID 61464

Thursday, August 26, 2010 11:31:46 AM



Page 1

Item ID: D2506

Accept



Setup Start



Revision ID:

Stop



Item Name: Label Plate

Start Date: 8/26/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-8-26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2506

Rev F

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2506
Deburr if necessary

☐ Dwg Rev:

F

☐ Prog Rev:

F

☐ 2-

B10-8-30

[Signature]

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B10-8-30

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S10/05/30

[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Required Date: 9/6/2010 Req'd Qty: 5.00

Reference:

Cust Item ID:




Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC Brake NC	NC BRAKE Memo 1-Form as per dwg D2506	0.00 0.00				(5)			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(XJ)			
150  Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00				(5)			

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Accept



Setup Start



Revision ID:

Stop



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Start Date: 8/26/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/13

10-9-10

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Picklist Print

Thursday, August 26, 2010 11:31:51 AM

Page 1

Work Order ID: 61464



Parent Item: D2506

Parent Item Name: Label Plate

Start Date: 8/26/2010

Required Date: 9/6/2010

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP B 01.06.08 Now laser cut EC
IPP C 06.12.13 ecn 822 ec
IPP Rev:D 08-12-01 rev.F as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

100

sf

118.2987

1.22

6.421053



304/316 .040 Sheet



10-8-30

Location

Loc Qty

Loc Code

MAT

16.1522

114574

16.1522

MAT20

102.1465

112885

2.7475

113062

0.699

115440

98.7

115440

(S)

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DART AEROSPACE LTD		Work Order: 67469
Description: Label Plate		Part Number: D2506
Inspection Dwg: D2506	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.50	+/-0.030	4.504	✓		V BO2	
1.31	+/-0.030	1.308	✓		V	
1.88	+/-0.030	1.882	✓		V	
32.63	+/-0.030	32.625	✓		T BO1	
39.00	+/-0.030	39.00	✓		T	
2.00	+/-0.030	2.997	✓		V	
0.063	+/-0.010	.065	✓		V	
1.00	+/-0.030	1.007	✓		V	
2.95	+/-0.030	2.951	✓		V	
0.040	+/-0.010	.035	✓		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-8-36	Date: 10/08/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.29	New Issue	KJ/JLM	
B	06.12.20	Dwg Rev. updated	KJ/JLM	
C	07.09.06	0.040 dimension added	KJ/JLM	
D	09.06.26	Dimensions update per Dwg Rev F	KJ	

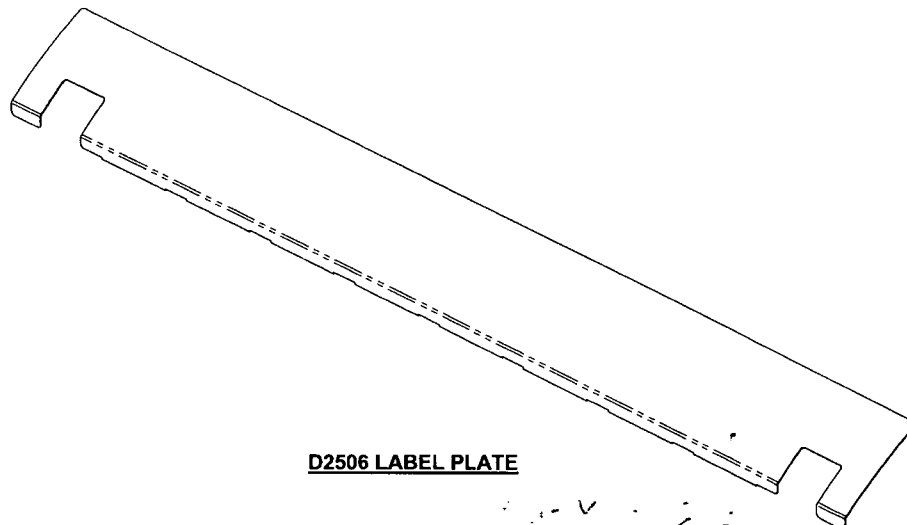
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D2506 LABEL PLATE

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41404
BS10-8-24

RELEASED
08/11/18

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 
REF. DART SPEC. M304S20GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.92 lbs

F	REDRAWN IN SOLIDWORKS TO CURRENT STANDARD AND TRANSFERRED TO "B" SIZE FORMAT; UPDATED NOTE 1 (ZN A6-1); ADDED DETAIL A (ZN C8-2); 124" ± 1" WAS 127" (ZN A4-2); REASONS: EASE MANUFACTURING WITH CORRECTION OF BEND AND ADDITION OF INTERMITTENT WELDING LOCATORS	MB	08.09.23
E	REMOVE 10" BEND; ADD NOTES; 127" WAS 126"	CB	06.11.20
D	32.63 WAS 32.25; 1.31 WAS 1.50	KE	98.10.04
C	RE-DESIGN OF LABEL PLATE	MM	96.09.04
B	RE-DESIGN OF LABEL PLATE	MM	96.06.18
A	NEW ISSUE	KH	95.11.26
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BS		
CHECKED	BS	DRAWING NO.	REV. F
MFG. APPR.	BS	D2506	SHEET 1 OF 2
APPROVED	BS	TITLE	SCALE
DE APPR.	BS	LABEL PLATE	NTS
DATE	08.09.23	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

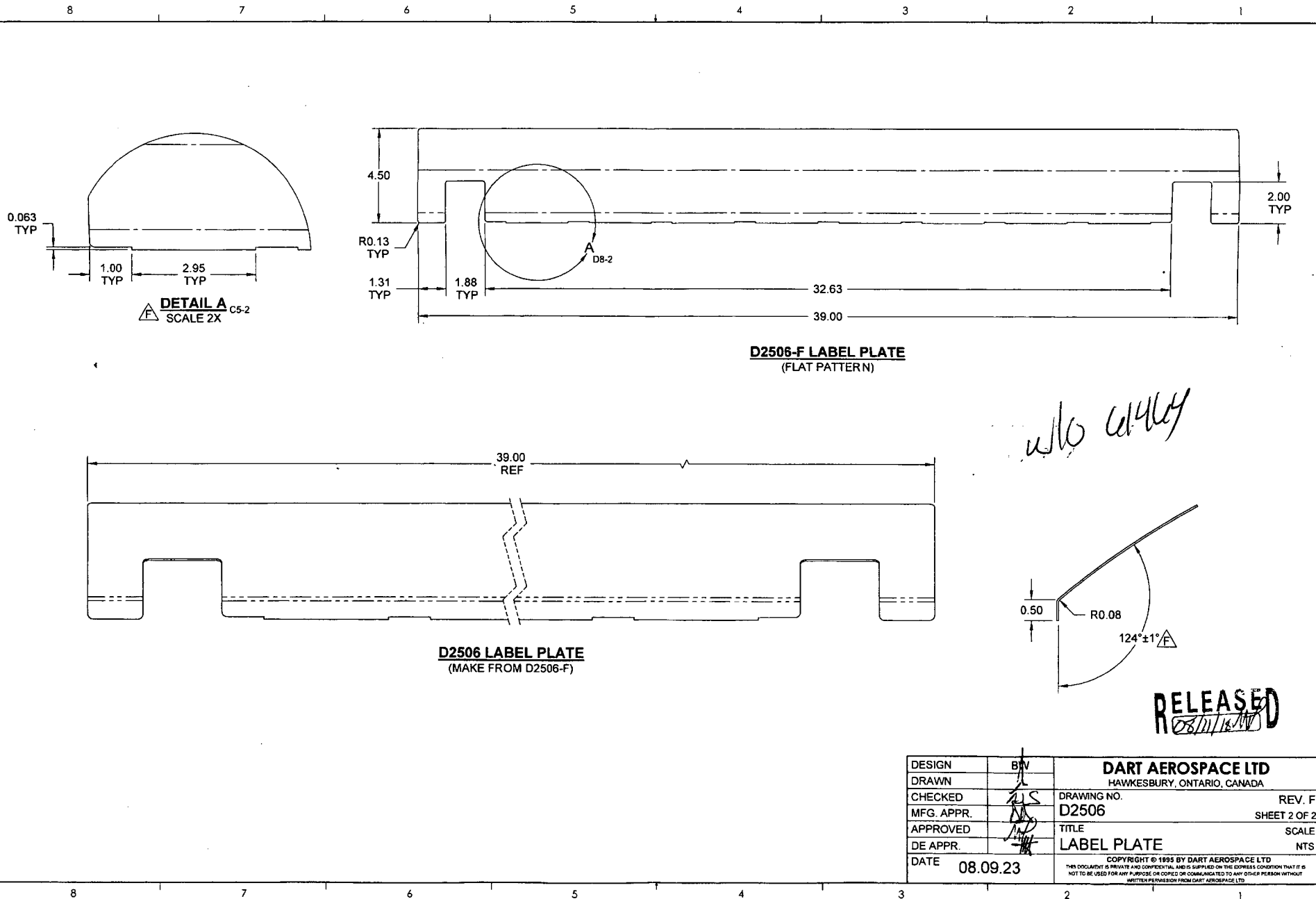
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DESIGN	BIV	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	ALS	DRAWING NO.	REV. F
MFG. APPR.		D2506	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LABEL PLATE	NTS
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